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01147

D350-591-213
Job Sheet 191637



Part No: D350-591-213

Job Qty: 4 pcs

Part Name: Heli-Access-Step™ LH - High Gear, Short Step, Aerazur Float Compatible



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/5/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 4/15/19

Description:

Note: DWG REV H IPP Rev:B 05.10.14 Modified step 10 KJ/EC IPP Rev:C 06-06-19 Added D2732-030 AS PER
DSI9294 JLMIPP REV:D 14.12.17 ADD DSI9712-011 DD VERF:JLM IPP Rev:C 06-06-27 Revised as per
DSI9340 JLM IPP Rev:D 10.03.17 incorporate seq 180 to 200 remove qc5 DD verified by:JLM IPP Rev:E
10.11.15 update qty on AN4-11A DD ver:EC IPP REV:F 16.03.16 IIN REV:H DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
270	Packaging 1 - Pick Kit	4 pcs	4/15/19		0.00	0.00	Packaging 1 - 1		
							Packaging 1 - 2		
							Packaging 1 - 3		
							Packaging 1 - 4		
							Packaging 1 - 5		
							Packaging 1 - 6		
							Packaging 1 - 7		
							Packaging 1 - 8		
							Packaging 1 - 9		
							Packaging 1 - 10		
							Packaging 1 - 11		
							Packaging 1 - 12		
							Packaging 1 - 13		
							Packaging 1 - 14		
							Packaging 1 - 15		
							Packaging 1 - 16		
							Packaging 1 - 17		
							Packaging 1 - 18		
							Packaging 1 - 19		
							Packaging 1 - 20		
							Packaging 1 - 21		
							Packaging 1 - 22		
							Packaging 1 - 23		
							Packaging 1 - 24		
							Packaging 1 - 25		
							Packaging 1 - 26		
							Packaging 1 - 27		
							Packaging 1 - 28		
							Packaging 1 - 29		



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Container No: S206806



Part: D350-591-213

Job No: 191637

Serial No/Batch: S206806

Revision:

Inspector:

Exp Date:

Instructions: TC STC SH92-6 Issue 14, FAA STC SH967NE 04/12/21, BRAZIL 19:

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				Packaging 1 - 30	
				Packaging 1 - 31	
				Packaging 1 - 32	
				Packaging 1 - 33	
				Packaging 1 - 34	
				Packaging 1 - 35	
				Packaging 1 - 36	
				280 QC 4	4 pcs
QC 4 - 28					
QC 4 - 42					
QC 4 - 58					
QC 4 - 6					
QC 4 - 69					
QC 4 - 9					
QC 4 - 46					
					DAS 78 9-89
290 Packaging 3-1 - Stock - B4B	4 pcs	4/15/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
					DAS 78 9-89
295 DC - 1 - B4B	4 pcs	4/15/19	0.00 0.00	DC - 1 - B4B	
				DC - 2 - B4B	
300 QC 21 - FG	4 pcs	4/15/19	0.00 0.00	QC 21 - FG - 21	
				QC 21 - FG - 70	
				QC 21 - SA - 53	
Part Op 280 - (QC4- 100% Inspect kits for completeness)					
Descriptions: 290 - Identify and pack for shipping as per PPP D350-591-213					

DAS
78
9-89

10/4/
2019

DAS
78
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2019

DAS
21
9-89

OCT 04 2019

DAS
21
9-89

OCT 04 2019

FG39

295 - (Document Control) Photocopy bluefile and type labels as per PPP D350-591-213 CHG005

300 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3-35A	Bolt	8 Ea (2 ea)	270-Packaging 1 - Pick Kit	SI58551
AN4-15A	Bolt	16 Ea (4 ea)	270-Packaging 1 - Pick Kit	SP34436215/SR2406x1
AN5-36A	Bolt	8 Ea (2 ea)	270-Packaging 1 - Pick Kit	SI58551
D2230-3	Mounting Lug	8 pcs (2 ea)	270-Packaging 1 - Pick Kit	SI727245185130x4
D2618	Bushing	8 pcs (2 ea)	270-Packaging 1 - Pick Kit	SI727245
D2732-030	Rubber Cushion - 3"	16 pcs (4 ea)	270-Packaging 1 - Pick Kit	SI58551
D3078-041	Step Assembly, HI Short LH	4 pcs (1 ea)	270-Packaging 1 - Pick Kit	SI58551
D3235-1	Mounting Lug	8 pcs (2 ea)	270-Packaging 1 - Pick Kit	SI500551215187397x6
D3338-1	Mounting Lug	4 pcs (1 ea)	270-Packaging 1 - Pick Kit	SI58551
MS21042L3	Nut	8 Ea (2 ea)	270-Packaging 1 - Pick Kit	SI58551
MS21042L4	Nut	24 Ea (6 ea)	270-Packaging 1 - Pick Kit	SI58551
MS21042L5	Nut	8 Ea (2 ea)	270-Packaging 1 - Pick Kit	SI58551
NAS1149D0363J	Washer	16 Ea (4 ea)	270-Packaging 1 - Pick Kit	SI58551
NAS1149D0463J	Washer	48 Ea (12 ea)	270-Packaging 1 - Pick Kit	SI58551
NAS1149D0563J	Washer	16 Ea (4 ea)	270-Packaging 1 - Pick Kit	SI58551
AN4-16A	Bolt	16 Ea (4 ea)	270-Packaging 1 - Pick Kit	SI58551

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
270-Packaging 1 - Pick Kit	AN3-35A	8	612	0
	AN4-15A	16	354	0
	AN4-16A	16	599	0
	AN5-36A	8	160	0
	D2230-3	8	197	0
	D2618	8	240	0
	D2732-030	16	426	0
	D3078-041	4	4	0
	D3235-1	8	270	0
	D3338-1	4	58	0
	MS21042L3	8	4,022	0
	MS21042L4	24	3,963	0
	MS21042L5	8	703	0
	NAS1149D0363J	16	1,102	0
	NAS1149D0463J	48	7,656	0
	NAS1149D0563J	16	1,736	0

Part Specifications

Specifications could not be found.

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Entered:

Date:

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No.

Route update only



Job: _____		DISPOSITION		DEPARTMENT/PROCESS		Engineering	
Part No. _____		Rework		Cross tube		Eng. (Non-AW)	
		Scrap		Small Fab		Prod. Eng. Coord.	
		Use-as-is		Finishing		Rec/Store/Packaging	
Date: _____		Sequence #: _____		QTY Affected: _____		MRB (QS1042)	
Description Work Order Deviation		Disposition					
		Completed By					
		Lead hand / Supervisor					
		QC / QA Coordinator					
Root Cause		FAULT CATEGORY					
Operator		Pressure/Forced		Contamination		Power Loss/Surge	
Manufacturing Process		Bending		Misaligned/off center		Folio/Program	
Equip/Tooling		Crushing		BOM/Route		Grain Direction	
Handling/Preservation		Cracks		Broken/Damage/Defect		Weld	
Material		Crimp/Kink/Ripple/Wave/Twist		Incomplete/Unclear Instructions		Wrong Stock Pulled	
Product Improvement		Marks/Chatter		Drill Holes		Out of Sequence	
Process Improvement		Mislabeled		Fit/Function		Off-set/Set-up	
Human Factors		Other/Details:					
		Positioned Wrong					
		Outside Tolerance					
		Drawing					
		Finish					
		Part Lost/Missing					
		Misread					

Change Record

PAGE 1 OF 1

Part Number: D350-591-213/-213GB/-214/-214GB

Description: HELI-ACCESS STEP, HIGH SKID, SHORT STEP, LH/RH

[illegible]

Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X						D350-591-213	<i>Half-Access-Step™</i> , Short Step – High Skid, LH
	X					D350-591-214	<i>Half-Access-Step™</i> , Short Step – High Skid, RH
		X				D350-591-215	<i>Half-Access-Step™</i> , Short Step – Low Skid, LH
			X			D350-591-216	<i>Half-Access-Step™</i> , Short Step – Low Skid, RH
				X		D350-591-311	<i>Half-Access-Step™</i> , Long Step – High Skid, LH
					X	D350-591-312	<i>Half-Access-Step™</i> , Long Step – High Skid, RH
1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
				1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
					1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
2	2	2	2	4	4	D2230-3	MOUNTING LUG
2	2	2	2	2	2	D2618	BUSHING
4	4	4	4			D2732-030	CUSHION
				2	2	D2856-400-720	ABRASION STRIP
2	2	2	2	2	2	D3235-1	MOUNTING LUG
				1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	AN3-35A	BOLT
				8	8	AN4-13A	BOLT
4	4	4	4			AN4-15A	BOLT
2	2	2	2	2	2	AN5-36A	BOLT
4	4	4	4	4	4	NAS1149D0363J	WASHER (AN960JD10)
12	12	12	12	16	16	NAS1149D0463J	WASHER (AN960JD416)
4	4	4	4	4	4	NAS1149D0563J	WASHER (AN960JD516)
2	2	2	2	2	2	MS21042L3	NUT
6	6	6	6	8	8	MS21042L4	NUT
2	2	2	2	2	2	MS21042L5	NUT
				1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 15 for installation of the DSI 9410-011 Kit.